

Work Order ID 65834

Wednesday, January 26, 2011 11:31:28 AM



Page 1

Item ID:	D3021-041	Accept		Setup	Start	
Revision ID:						
Item Name:	Tube Assembly				Stop	
Start Date:	1/26/2011	Start Qty:	1.00			
Required Date:	1/26/2011	Req'd Qty:	1.00			
Reference:						

Approvals:	Process Plan:		Date:	11-01-24	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3021	Rev A								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Cut tube as per Dwg D3021								
	2-Drill tube as per Dwg D3021 using D8622								
	3-Deburr								
	4-Weld as per Dwg D3021 QSI004								
	A/R 4130 Rod Batch: 100075								
110		0.00							
	QC9- Inspct visual per QSI004- Fusion Welds								
QC	Memo	0.00							
Quality Control									

EL 11-3-30 (X1)

1 Ø BE11/03/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

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Setup Start

Stop.

**Cust Item ID:**

10

Customer:

Reference:

Run Start

00000000000000000000000000000000

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

2010/03/30

0.00

QC

Memo

Quality Control

0.00

M115128

0.00

Powdercoat

Memo

Powder Coating

START TIME: 7:10
OVEN TEMPERATURE: 320°
FINISH TIME: 7:40

0.00

140

[illegible]

0.00

QC

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



Work Order ID 65834




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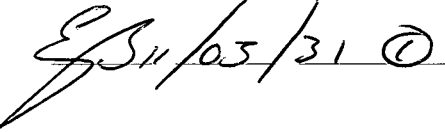
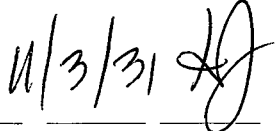
Wednesday, January 26, 2011 11:31:28 AM

Item ID: D3021-041 Accept  Setup Start 
Revision ID: Stop 
Item Name: Tube Assembly
Start Date: 1/26/2011 Start Qty: 1.00  Cust Item ID:
Required Date: 1/26/2011 Req'd Qty: 1.00  Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging	Identify as per dwg & Stock Location: <u>G-A</u> Memo <u>w/o 65831</u> 	0.00							
160  QC	QC21- Final Inspection - Work Order Release Memo	0.00							
Quality Control									

EB 11/03/31 
11/3/31 
MF
11-03-31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Wednesday, January 26, 2011 11:31:34 AM

Page 1

Work Order ID: 65834

Parent Item: D3021-041

Parent Item Name: Tube Assembly

Start Date: 1/26/2011


Required Date: 1/26/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP 01.10.23 New Issue SM


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D3017-11		Manufactured	No			100	Each	17.0000	2	2			
													
cap													

Location Loc Qty Loc Code

WA 17

52583 17

M4130NT0.750W.049		Purchased	No			100	f	105.5417	2.0833	2.192947			
													
4130 RD Tube .750 x.049W													

Location Loc Qty Loc Code

MAT033 105.5417

10133 13

110740 92.5417

already out of stock, was in my scraps from other seat.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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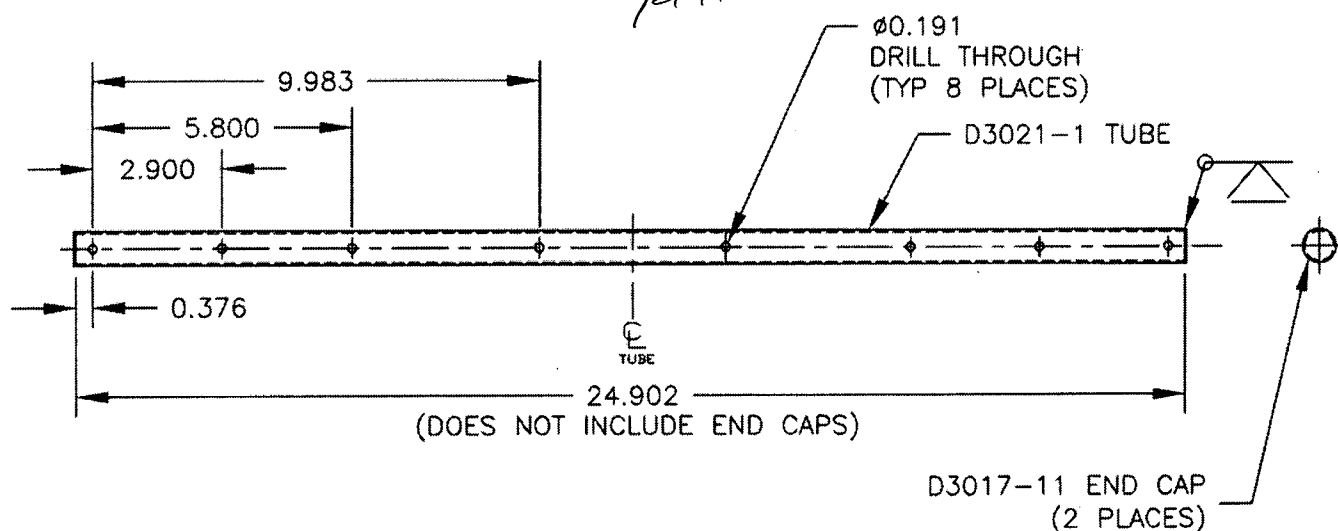
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DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *65834*
PL11-01-26



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries